Date:

Wednesday, 10/11/2006 11:11:18 AM

Kim Johnston User: **Process Sheet** : CU-DAR001 Dart Helicopters Services : STOP Customer **Drawing Name** Job Number : 28914A **Estimate Number** : 10731 :NIA : D23243 Part Number P.O. Number S.O. No. : NA : 10/11/2006 D2324 REV. C This Issue **Drawing Number** Prsht Rev. **Project Number** : N/A : NIA : SMALL /MED FAB First Issue Туре **Drawing Revision** : 28062A Material **Previous Run** : 10/30/2006 **Due Date** Each Qty: 1 Um: Written By Checked & Approved By Comment Reformat; Incorporated D2324-3 & D2324-5 K : Est: J/RF **Additional Product** Job Number: Seq. #: Description: M6061T6B0750X00750 1.0 6061-T6 Bar .75" x .75" Comment: Qty.: 0.5565 f(s)/Unit Total: 0.5565 f(s) 6061-T6 Bar 0.75" x 0.75" Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8) Batch: M102476 (M6061T6B0.750x00.750) BAND SAW 2.0 BAND SAW Comment: BAND SAW Cut blanks: (0.75" x 0.75") x 5.75" Long Bar 3.0 Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges Identify as D2324-3 QC2 INSPECT PARTS AS THEY COME OFF MACHINE 4.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1 5.0 SECOND CHECK Comment: SECOND CHECK

Dart Ae	rospace Lt	td						4.4	
W/O:			WC	ORK ORDER CHANGE	S			1	-
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								i	
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	∑ Date: ≥	411/03
					QA: N	/C Close	d:	_ Date: _	
NCR:			WORK ORDI	ER NON-CONFORMAI	NCE (NCF	₹)			
DATE	OTED	Description of NC	NC Corrective Action Section			Verificatio		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
				,					

NOTE: Date & initial all entries

Wednesday, 10/11/2006 11:11:18 AM Date: .User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STOP Job Number: 28914A Part Number: D23243 Job Number: Seq. #: Machine Or Operation: Description: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 OWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT ALODINE PACKAGING 1 PACKAGING RESOURCE # 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock FINAL INSPECTION/W/O RÉLEASE 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

	. Jopass									
W/O:			WC	RK ORDER CHA	NGES				<u> </u>	
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		4							,	
				L.					Ţ	
	:		•						!	
					İ				i	
Part No	·	PAR #:	Fault Cate	gory:	NCI	R: Yes I	No DQA	\ :	Date:	<u> </u>
						QA: N/	C Closed	d:	_ Date: _	
NCR:		V	VORK ORDI	ER NON-CONFOR	RMANCE	(NCR)		1	
DATE	STEP	Description of NC	Corrective Action Section B				Verification		Approval	Approval
DATE	Section A		Initial Chief Eng	Action Description Chief Eng	on ———	Sign & Date		on C	Chief Eng	QC Inspector
									1	
		(4)							k.	
	:									
					٠.				-	
		·								
•										
					.0	· · · · · · · · · · · · · · · · · · ·			1	
		ar .							ļ	
									!	. 4

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28914A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	80.259				
Ø0.191	+/-0.010	80.193				
0.750	+/-0.010	0.752				
0.375	+/-0.010	6.3 75	1			
1.875	+/-0.010	1.875	_			
5.250	+/-0.010	5.250				
5.625	+/-0.010	5-627				
		,				
	-					
		1				

Measured by:	The	Audited by:		Prototype Approval:	N/A
Date:	01/11/02	Date:	06/11/02	Date:	N/A

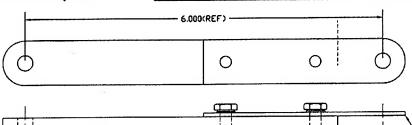
Rev	Date	Change		Revised by	Approved
Α	04.06.10	New Issue	P/O D2324-1	KJ/JLM	-1
В	06.03.08	Dwg Rev changed		KJ/JLM A	



DESIGN DRAWN BY DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA B WILLIAMS PH REV. C CHECKED DRAWING NO. APPROVED SHEET 1 OF 1 D2324 SCALE TITLE DATE 04.12.14 **STRUT NEW ISSUE** 94,11.08 Α В 96.05.07 UPDATE MATERIALS 04.12.14 UPDATE NOTES C

02324-5

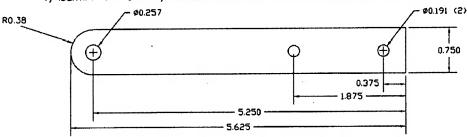
RELEASED 04.12.16



D2324 STRUT ASSEMBLY

D2324-3

AN3-12A BOLT (1) AN960JD10 WASHER (2) MS21042L3 NUT (1) (TWO PLACES) 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324 - 3

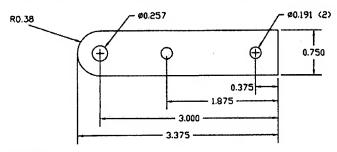
1)_MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75

(REF DART SPEC. M6061T6B0.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2). FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
 POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK OF D